



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D407-667-205**  
**Job Sheet 179372**



Part No: D407-667-205

Job Qty: 1 ea

Part Name: Aft Crosstube - High 407



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/18/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

**Note:** DWG REV G IPP Rev:C 05.09.02 Add holes for comp. w/ Bell Skids KJ/JLM IPP Rev:D Add Magnobond,Rubber Cushion,Clamps 07-02-19 JLM IPP Rev:E 08-05-22 add comment seq. 6 & QC15 & QC5 DD verf:EC IPP Rev:F 08-06-12 add comment seq. 24 DD verf:EC IPP Rev:G 08-08-19 revE per dwg DD verf:EC IPP Rev H 09.01.06 ECN 08-562 EC verf:DD IPP Rev:I 10.04.07 revise route seq. in born DD verf:JLM IPP Rev J 11.04.26 removed abrasion strip ecn 11-551 EC verf:DD IPP REV:K 11.10.03 DEOD407-667-245-F-2 DD verf:EC

Ship Via:

624

### Bill of Materials

### Job Routing

| Op No | Operation           | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off      |
|-------|---------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|---------------|
|       |                     |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |               |
| 90    | Start up Operation  | 1 Ea  | 7/6/18     | 7/6/18   | 0.00      | 0.00    | Start Up Stores/Pkg-1 |           | GP 2018-08-17 |
| 110   | Packaging           | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 0.00    | Packaging1-4          |           | Sp 2018-08-17 |
| 120   | CNC Bend Skid tubes | 1 pcs | 7/6/18     | 7/6/18   | 1.99      | 3.33    | CNC Bend Skid tube    |           | GP 2018-08-17 |
| 130   | QC                  | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 0.00    | QC15                  |           | 38            |
| 140   | Crosstubes          | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 3.47    | Crosstubes-2          |           | DPZ 9-88      |
| 150   | HandFXtube          | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 0.91    | HandFinish5           |           | DPZ 9-88      |
| 160   | QC                  | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 0.00    | QC7-3                 |           | 38            |
| 170   | QC                  | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 0.00    | QC5                   |           | 38            |
| 180   | Outsource           | 1 pcs | 7/6/18     | 7/6/18   |           |         | SKY002-VC             | 2         | 9-88          |
| 190   | Packaging           | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 0.00    | Packaging2            |           | SEP 13 2018   |
| 200   | QC                  | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 0.00    | QC6                   |           | 38            |
| 210   | SprayPaint          | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 1.39    | Spray Paint           |           | 18-10-23      |
| 220   | QC                  | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 0.00    | QC14                  |           | 18-11-9       |
| 230   | Crosstubes          | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 3.47    | Crosstubes-2          |           | SA 18/11/19   |
| 240   | QC                  | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 0.00    | QC5                   |           | 38            |
| 250   | Packaging           | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 0.00    | Packaging1-4          |           | 9-88          |
| 260   | QC                  | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 0.00    | QC4                   |           | DAS 69        |
| 265   | DC                  | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 0.00    | DC                    |           | 9-89          |
| 270   | Packaging           | 1 pcs | 7/6/18     | 7/6/18   | 0.00      | 0.00    | Packaging3-2          |           | 21            |
| 280   | QC21-FG             | 1 Ea  | 7/6/18     | 7/6/18   | 0.00      | 0.00    | QC21                  |           | 21            |

Part Op 120 - 1-Bend tube as per Dwg D407-667-245 using CNC bender program 407 Aft and Folio 21

Descriptions: 140 - \*\*\*\*\* ENSURE PROPER JIG POSITIONING BEFORE DRILLING\*\*\*\*\* , VERIFIED BY:

\*\*\*\*\* 1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill all (3) top holes. Holes facing inboard. Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245 2- Drill fwd rivet holes using drill Jig DT8787 fwd as per Dwg D407-667-245. Note: FWD side has 3X top holes facing inboard. 3- C'sink holes as per dwg D407-667-245. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. Drill ONLY 2 top holes ONLY plug most bottom hole to prevent accidental drilling. Drill holes and ream using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill only the top (2) holes. Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245 5-Drill aft rivet holes using drill Jig DT8787 aft as per Dwg D407-667-245. Drill only the top (2) holes. 6- C'sink holes as per dwg D407-667-245. Allow rivet to sit below surface to compensate for paint. 8-\*\*\* WEAR LATEX



DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                     | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> |                                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Cross tube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> |             |                          |                       |                                                 |        | Skid-tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |             |                          |               |                          |                    |                          |              |                          |                  |                          |          |                          |             |                          |                    |                          |             |                          |                     |                          |                  |                          |                       |                          |               |                          |            |                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                          |                  |                          |                       |                          |                  |                          |                    |                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |                |             |                   |       |                  |    |                    |  |                      |   |                |             |                   |      |            |  |         |  |        |   |         |             |                  |
| Skid-tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     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| Machining <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Small Fab <input type="checkbox"/>  | Prod. 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Coord. <input type="checkbox"/>                                                                                                                                         | Quality <input type="checkbox"/>     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         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| Thermoforming <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Large Fab <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     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| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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| <div style="position: relative; height: 200px;"> <div style="position: absolute; top: 50%; left: 50%; transform: translate(-50%, -50%); font-size: 0.8em;">           DART Aerospace Ltd.<br/>           1270 Aberdeen Street<br/>           Newmarket, ON K6A 1K7<br/>           CANADA<br/>           TEL.: 1 613 632-6200<br/>           Email: sales@dartero.com<br/>           www.dartaerospace.com         </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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                                                                                                                                                                                                                                                                                                                                                                                           |             |                          |                       | Lead hand / Supervisor<br>Approval Verification |        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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type="checkbox"/> | Manufacturing Process | <input type="checkbox"/> | Misidentified | <input type="checkbox"/> | Past Due   | <input type="checkbox"/> | <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Surge</td> <td style="width:15%;">Positioned Wrong</td> </tr> <tr> <td>am</td> <td>Outside Dimensions</td> </tr> <tr> <td></td> <td>Over/Under tolerance</td> </tr> <tr> <td></td> <td>Part Incorrect</td> </tr> <tr> <td>Link Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>ence</td> <td>Part Moved</td> </tr> <tr> <td></td> <td>Drawing</td> </tr> <tr> <td></td> <td>Finish</td> </tr> <tr> <td>n</td> <td>Misread</td> </tr> <tr> <td>/off center</td> <td>Turning Sequence</td> </tr> </table> |                          |                  |                          |                       | Surge                    | Positioned Wrong | am                       | Outside Dimensions |                          | Over/Under tolerance                                           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GLOVES WHEN HANDLING CROSSTUBE\*\*\*Debur & Inspect for surface damage. Repair damage within limits as per Dwg D407-667-245

DAS  
13  
9-89

150 - \*\*\*IMMEDIATELY AFTER GRINDING\*\*\*

180 - \*\*\* WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE\*\*\* Liquid Penetrant Inspection as per QSI 0380

190 - \*\*\* WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE\*\*\*

200 - \*\*\* WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE\*\*\*

210 - \*\*\* WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE\*\*\* 1-Prime inside and outside crosstube as per DEO D407-667-245 and QSI 005 4.2 \*\*\*Mask underside of crosstube as shown\*\*\* 3- Apply clear coat as per dwg Clear Coat Batch: 138832 Prime 138762 Paint 138956

220 - Then,Wrap in plastic bag to protect from scratches

230 - 1- Install chaffing shield as per D407-667-245 using DT10096 to establish 8.90 dimension. Top holes should be facing up. \*\*\*\*Ensure chaffing is to be position "overlap" AFT\*\*\*\* A/R Proseal 890 Batch: 5096394 EXP: 3/19 2-

Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe 3-Install support with Scotch-Weld DP460 and install clamps as per Dwg D407-667-245 using installation jig DT9025. Torque clamps as per dwg A/R Scotch-Weld DP460 Batch: 138955 EXP: 4/19 \*\*\*LET CURE FOR 24

HOURS\*\*\* CURE TIME: START: 18/11/19 FINISH: 19/11/20 4-Install nut plates as per Dwg D407-667-245. Touch-up rivet heads with Imron paint.

240 - \*\*\*RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURE FOR 24HOURS AS PER DWG DEO\*\*\*

265 - Photocopy bluefile and create labels as per PPP D407-667-205 CHG009

270 - Identify and in kanban rack

### Job BOM

| Part / Item     | Component Name                         | Quantity      | Operation             | Container        |
|-----------------|----------------------------------------|---------------|-----------------------|------------------|
| D407-667-205TRN | Crosstube Turning Detail               | 1 Ea (1 ea)   | 90-Start up Operation |                  |
| D2873-043       | Nut Plate Assembly                     | 2 Ea (2 ea)   | 230-Crosstubes        |                  |
| D2873-045       | Nut Plate Assembly                     | 2 Ea (2 ea)   | 230-Crosstubes        |                  |
| D2894-1         | 2.75 Support                           | 1 Ea (1 ea)   | 230-Crosstubes        |                  |
| D3190-1         | Chaffing Shield                        | 2 Ea (2 ea)   | 230-Crosstubes        |                  |
| D3595-063-430   | Rubber Cushion 0.63" Wide X 4.30" Long | 2 Ea (2 ea)   | 230-Crosstubes        |                  |
| MS20601-AD4W8   | Rivet                                  | 14 Ea (14 ea) | 230-Crosstubes        |                  |
| MS21920-22      | Clamp                                  | 4 Ea (4 ea)   | 230-Crosstubes        |                  |
| MS21920-25      | Clamp                                  | 2 Ea (2 ea)   | 230-Crosstubes        |                  |
| NAS1149D0563J   | Washer                                 | 18 Ea (18 ea) | 230-Crosstubes        | <u>5050053</u>   |
| AN5-10A         | Bolt                                   | 10 Ea (10 ea) | 250-Packaging         | <u>5089233</u>   |
| AN5-32A         | Bolt                                   | 4 Ea (4 ea)   | 250-Packaging         | <u>5058983-1</u> |
| AN5-34A         | Bolt                                   | 4 Ea (4 ea)   | 250-Packaging         | <u>5019410</u>   |
| MS21042L5       | Nut                                    | 4 Ea (4 ea)   | 250-Packaging         | <u>5093562</u>   |

### Job Allocations

| Operation             | Component Part               | Required | Inventory | Allocated |
|-----------------------|------------------------------|----------|-----------|-----------|
| 90-Start up Operation | D407-667-205TRN              | 1        | 0         | 0         |
| 230-Crosstubes        | D2873-043 <u>5090584</u>     | 2        | 19        | 0         |
|                       | D2873-045 <u>5050880</u>     | 2        | 23        | 0         |
|                       | D2894-1 <u>5054586</u>       | 1        | 10        | 0         |
|                       | D3190-1 <u>138929</u>        | 2        | 69        | 0         |
|                       | D3595-063-430 <u>5074227</u> | 2        | 40        | 0         |
|                       | MS20601-AD4W8 <u>5066984</u> | 15       | 228       | 0         |
|                       | MS21920-22 <u>505461</u>     | 4        | 66        | 0         |
|                       | MS21920-25 <u>5122604</u>    | 2        | 140       | 0         |
|                       | NAS1149D0563J                | 18       | 1,979     | 0         |
| 250-Packaging         | AN5-10A                      | 10       | 151       | 0         |
|                       | AN5-32A                      | 4        | 390       | 0         |
|                       | AN5-34A                      | 4        | 89        | 0         |
|                       | MS21042L5                    | 4        | 583       | 0         |

### Part Specifications

Specifications could not be found.



DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                              |  |                                                                                                                                                                                               |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                  |  |
|--------------------------------------------------------------|--|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ |  | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input checked="" type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> |  | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Thermoforming <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input checked="" type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/><br/>           Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/><br/>           Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Quality <input type="checkbox"/><br/>           Other <input type="checkbox"/> </div> </div> |  |                                                                  |  |
| Date : <u>18/8/20</u>                                        |  | Step #:                                                                                                                                                                                       |  | QTY Effective :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | MRB (QSI042) Approval<br><u>INSP</u><br><u>12</u> <u>18/8/20</u> |  |
| Description Work Order Deviation                             |  |                                                                                                                                                                                               |  | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |                                                                  |  |
| After bending: Angles are under tolerance.                   |  |                                                                                                                                                                                               |  | Acceptable.<br>Will not cause fit issue.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  |                                                                  |  |
|                                                              |  |                                                                                                                                                                                               |  | Completed By<br><u>18/8/20</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |                                                                  |  |
|                                                              |  |                                                                                                                                                                                               |  | Lead hand / Supervisor<br>Approval Verification                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                  |  |
|                                                              |  |                                                                                                                                                                                               |  | QC / QA Coordinator<br>Approval                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                  |  |

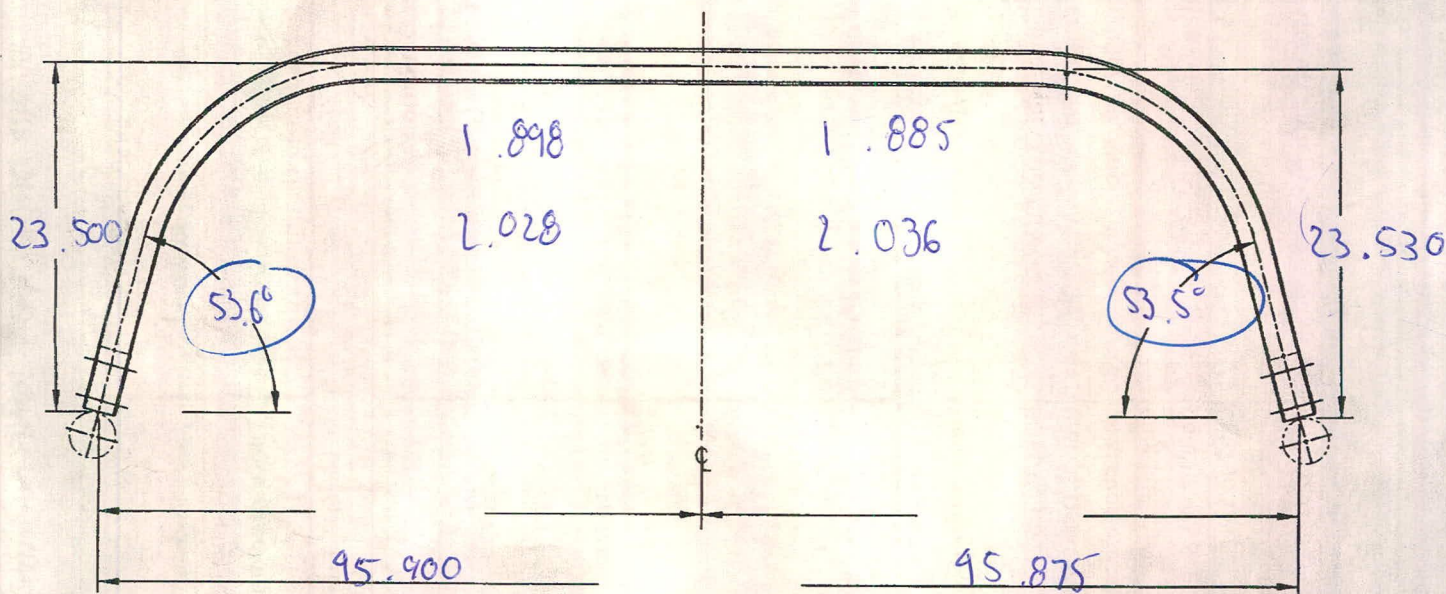
  

| Root Cause                                  |                                                |                                                 | FAULT CATEGORY                                             |                                                |                                               |
|---------------------------------------------|------------------------------------------------|-------------------------------------------------|------------------------------------------------------------|------------------------------------------------|-----------------------------------------------|
| Environment <input type="checkbox"/>        | No Re-verification <input type="checkbox"/>    | Pressure/Forced <input type="checkbox"/>        | Temperature/Cure <input type="checkbox"/>                  | Power Loss/Surge <input type="checkbox"/>      | Positioned Wrong <input type="checkbox"/>     |
| Design <input type="checkbox"/>             | Operator <input type="checkbox"/>              | Bending <input type="checkbox"/>                | Set-up <input type="checkbox"/>                            | Folio/Program <input type="checkbox"/>         | Outside Dimensions <input type="checkbox"/>   |
| Doc/Data <input type="checkbox"/>           | Offset/Setup <input type="checkbox"/>          | Centre Not Concentric <input type="checkbox"/>  | BOM/Route <input type="checkbox"/>                         | Grain <input type="checkbox"/>                 | Over/Under tolerance <input type="checkbox"/> |
| Equip/Tooling <input type="checkbox"/>      | Supplier <input type="checkbox"/>              | Cracks <input type="checkbox"/>                 | Broken/Damage/Defect <input type="checkbox"/>              | Weld <input type="checkbox"/>                  | Part Incorrect <input type="checkbox"/>       |
| Handling/Pre <input type="checkbox"/>       | Training <input type="checkbox"/>              | Crimp/Kink/Ripple/Wave <input type="checkbox"/> | Inspection Incomplete/Unqualified <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/>    | Part Lost/Missing <input type="checkbox"/>    |
| Material <input type="checkbox"/>           | Use for Testing <input type="checkbox"/>       | Cuffs <input type="checkbox"/>                  | Contamination <input type="checkbox"/>                     | Out of Sequence <input type="checkbox"/>       | Part Moved <input type="checkbox"/>           |
| Internal Transport <input type="checkbox"/> | Poor Information <input type="checkbox"/>      | Crushing <input type="checkbox"/>               | Countersink <input type="checkbox"/>                       | Off-set <input type="checkbox"/>               | Drawing <input type="checkbox"/>              |
| Tribal Knowledge <input type="checkbox"/>   | Rushing <input type="checkbox"/>               | Heat Treat <input type="checkbox"/>             | Cut Too Short <input type="checkbox"/>                     | Mislabeled <input type="checkbox"/>            | Finish <input type="checkbox"/>               |
| LOA <input type="checkbox"/>                | Product Improvement <input type="checkbox"/>   | Wave/Twist in Tube <input type="checkbox"/>     | Instructions Incomplete/Unclear <input type="checkbox"/>   | Fit/Function <input type="checkbox"/>          | Misread <input type="checkbox"/>              |
| Substation <input type="checkbox"/>         | Process Improvement <input type="checkbox"/>   | Marks/Chatter <input type="checkbox"/>          | Drill Holes <input type="checkbox"/>                       | Misaligned/off center <input type="checkbox"/> | Turning Sequence <input type="checkbox"/>     |
| Past Expiry Date <input type="checkbox"/>   | Manufacturing Process <input type="checkbox"/> | OTHER :                                         |                                                            |                                                |                                               |
| Misidentified <input type="checkbox"/>      | Past Due <input type="checkbox"/>              |                                                 |                                                            |                                                |                                               |



|                                       |  |              |              |
|---------------------------------------|--|--------------|--------------|
| DART AEROSPACE LTD                    |  | Work Order:  | 179372       |
| Description: Crosstube High Aft (407) |  | Part Number: | D407-667-205 |
| Inspection Dwg: D407-667-245 Rev: G   |  | Page 1 of 1  |              |

| Required Dimension | Min   | Max    |
|--------------------|-------|--------|
| Height             | 23.39 | 23.65  |
| 1/2 Span           | 45.79 | 46.05  |
| Angle              | 54    | 56     |
| Total Span         | 91.58 | 92.100 |
| Bending Passes     | 6     | --     |
| Crushing           | --    | 6%     |



|                | Side A | Side B |
|----------------|--------|--------|
| Bending Passes | 36     | 38     |
| Crushing       | 3.3%   | 3.8%   |
| Comments       |        |        |
|                |        |        |
|                |        |        |
|                |        |        |
|                |        |        |

|                 |  |
|-----------------|--|
| QC15 Inspection |  |
| Date            |  |

| Rev | Date     | Change                             | Revised by | Approved |
|-----|----------|------------------------------------|------------|----------|
| A   | 07.02.06 | New Issue                          | KJ/JM      |          |
| B   | 09.06.22 | Dwg Rev updated                    | KJ         |          |
| C   | 11.08.22 | Dimensions updated                 | KJ         |          |
| D   | 11.09.30 | Dimensions updated                 | KJ         |          |
| E   | 12.04.16 | Added bending, crushing dimensions | KJ         |          |
| F   | 15.05.14 | Dwg Rev updated                    | KJ         |          |



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube <input type="checkbox"/></td> <td style="border: none;">Cross tube <input type="checkbox"/></td> <td style="border: none;">Water Jet <input type="checkbox"/></td> <td style="border: none;">Engineering <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Machining <input type="checkbox"/></td> <td style="border: none;">Small Fab <input type="checkbox"/></td> <td style="border: none;">Prod. Eng. Coord. <input type="checkbox"/></td> <td style="border: none;">Quality <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Thermoforming <input type="checkbox"/></td> <td style="border: none;">Finishing <input type="checkbox"/></td> <td style="border: none;">Rec/Store/Packaging <input type="checkbox"/></td> <td style="border: none;">Other <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Large Fab <input type="checkbox"/></td> <td style="border: none;">Composite <input type="checkbox"/></td> <td style="border: none;">Supplier <input type="checkbox"/></td> <td></td> </tr> </table> |                                               |                                              |                                   | Skid-tube <input type="checkbox"/> | Cross tube <input type="checkbox"/>   | Water Jet <input type="checkbox"/>     | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/>    | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/>         | Thermoforming <input type="checkbox"/>      | Finishing <input type="checkbox"/>        | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>   | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/>           | Supplier <input type="checkbox"/>   |                                              |                                           |                                                |                                        |                                   |                                                                                                                                                                                                                                                                                                                                                                                                                              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| <b>Root Cause</b><br><table style="width:100%; border: none;"> <tr> <td style="border: none;">Environment <input type="checkbox"/></td> <td style="border: none;">No Re-verification <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Design <input type="checkbox"/></td> <td style="border: none;">Operator <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Doc/Data <input type="checkbox"/></td> <td style="border: none;">Offset/Setup <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Equip/Tooling <input type="checkbox"/></td> <td style="border: none;">Supplier <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Handling/Pre <input type="checkbox"/></td> <td style="border: none;">Training <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Material <input type="checkbox"/></td> <td style="border: none;">Use for Testing <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Internal Transport <input type="checkbox"/></td> <td style="border: none;">Poor Information <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Tribal Knowledge <input type="checkbox"/></td> <td style="border: none;">Rushing <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">LOA <input type="checkbox"/></td> <td style="border: none;">Product Improvement <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Substation <input type="checkbox"/></td> <td style="border: none;">Process Improvement <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Past Expiry Date <input type="checkbox"/></td> <td style="border: none;">Manufacturing Process <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Misidentified <input type="checkbox"/></td> <td style="border: none;">Past Due <input type="checkbox"/></td> </tr> </table> |                                                                                                                                                                                    | Environment <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | No Re-verification <input type="checkbox"/>   | Design <input type="checkbox"/>              | Operator <input type="checkbox"/> | Doc/Data <input type="checkbox"/>  | Offset/Setup <input type="checkbox"/> | Equip/Tooling <input type="checkbox"/> | Supplier <input type="checkbox"/>    | Handling/Pre <input type="checkbox"/> | Training <input type="checkbox"/>  | Material <input type="checkbox"/>          | Use for Testing <input type="checkbox"/> | Internal Transport <input type="checkbox"/> | Poor Information <input type="checkbox"/> | Tribal Knowledge <input type="checkbox"/>    | Rushing <input type="checkbox"/> | LOA <input type="checkbox"/>       | Product Improvement <input type="checkbox"/> | Substation <input type="checkbox"/> | Process Improvement <input type="checkbox"/> | Past Expiry Date <input type="checkbox"/> | Manufacturing Process <input type="checkbox"/> | Misidentified <input type="checkbox"/> | Past Due <input type="checkbox"/> | <b>FAULT CATEGORY</b><br><table style="width:100%; border: none;"> <tr> <td style="border: none;">Pressure/Forced <input type="checkbox"/></td> <td style="border: none;">Temperature/Cure <input type="checkbox"/></td> <td style="border: none;">Power Loss/Surge <input type="checkbox"/></td> <td style="border: none;">Positioned Wrong <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Bending <input type="checkbox"/></td> <td style="border: none;">Set-up <input type="checkbox"/></td> <td style="border: none;">Folio/Program <input type="checkbox"/></td> <td style="border: none;">Outside Dimensions <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Centre Not Concentric <input type="checkbox"/></td> <td style="border: none;">BOM/Route <input type="checkbox"/></td> <td style="border: none;">Grain <input type="checkbox"/></td> <td style="border: none;">Over/Under tolerance <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Cracks <input type="checkbox"/></td> <td style="border: none;">Broken/Damage/Defect <input type="checkbox"/></td> <td style="border: none;">Weld <input type="checkbox"/></td> <td style="border: none;">Part Incorrect <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Crimp/Kink/Ripple/Wave <input type="checkbox"/></td> <td style="border: none;">Inspection Incomplete/Unqualified <input type="checkbox"/></td> <td style="border: none;">Wrong Stock Pulled <input type="checkbox"/></td> <td style="border: none;">Part Lost/Missing <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Cuffs <input type="checkbox"/></td> <td style="border: none;">Contamination <input type="checkbox"/></td> <td style="border: none;">Out of Sequence <input type="checkbox"/></td> <td style="border: none;">Part Moved <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Crushing <input type="checkbox"/></td> <td style="border: none;">Countersink <input type="checkbox"/></td> <td style="border: none;">Off-set <input type="checkbox"/></td> <td style="border: none;">Drawing <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Heat Treat <input type="checkbox"/></td> <td style="border: none;">Cut Too Short <input type="checkbox"/></td> <td style="border: none;">Mislabeled <input type="checkbox"/></td> <td style="border: none;">Finish <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Wave/Twist in Tube <input type="checkbox"/></td> <td style="border: none;">Instructions Incomplete/Unclear <input type="checkbox"/></td> <td style="border: none;">Fit/Function <input type="checkbox"/></td> <td style="border: none;">Misread <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Marks/Chatter <input type="checkbox"/></td> <td style="border: none;">Drill Holes <input type="checkbox"/></td> <td style="border: none;">Misaligned/off center <input type="checkbox"/></td> <td style="border: none;">Turning Sequence <input type="checkbox"/></td> </tr> </table> |  |  | Pressure/Forced <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/> | Bending <input type="checkbox"/> | Set-up <input type="checkbox"/> | Folio/Program <input type="checkbox"/> | Outside Dimensions <input type="checkbox"/> | Centre Not Concentric <input type="checkbox"/> | BOM/Route <input type="checkbox"/> | Grain <input type="checkbox"/> | Over/Under tolerance <input type="checkbox"/> | Cracks <input type="checkbox"/> | Broken/Damage/Defect <input type="checkbox"/> | Weld <input type="checkbox"/> | Part Incorrect <input type="checkbox"/> | Crimp/Kink/Ripple/Wave <input type="checkbox"/> | Inspection Incomplete/Unqualified <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/> | Cuffs <input type="checkbox"/> | Contamination <input type="checkbox"/> | Out of Sequence <input type="checkbox"/> | Part Moved <input type="checkbox"/> | Crushing <input type="checkbox"/> | Countersink <input type="checkbox"/> | Off-set <input type="checkbox"/> | Drawing <input type="checkbox"/> | Heat Treat <input type="checkbox"/> | Cut Too Short <input type="checkbox"/> | Mislabeled <input type="checkbox"/> | Finish <input type="checkbox"/> | Wave/Twist in Tube <input type="checkbox"/> | Instructions Incomplete/Unclear <input type="checkbox"/> | Fit/Function <input type="checkbox"/> | Misread <input type="checkbox"/> | Marks/Chatter <input type="checkbox"/> | Drill Holes <input type="checkbox"/> | Misaligned/off center <input type="checkbox"/> | Turning Sequence <input type="checkbox"/> |
| Environment <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   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| Internal Transport <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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| Pressure/Forced <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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                                              | Power Loss/Surge <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                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| Bending <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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                                              | Folio/Program <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   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| Centre Not Concentric <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         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                                              | Grain <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           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| Cracks <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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| Crimp/Kink/Ripple/Wave <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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                                              | Wrong Stock Pulled <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| Cuffs <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         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                                              | Out of Sequence <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Crushing <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      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                                              | Off-set <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         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| Heat Treat <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    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| Wave/Twist in Tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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                                              | Fit/Function <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    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| Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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                                              | Misaligned/off center <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           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| Item | QTY<br>-245 | PART NUMBER       | DESCRIPTION                       |
|------|-------------|-------------------|-----------------------------------|
|      | X           | D407-667-245      | CROSSTUBE ASSEMBLY (407 HIGH AFT) |
| 1    | 1           | D6011-115         | CROSSTUBE                         |
| 2    | 2           | D2873-043         | NUT PLATE                         |
| 3    | 2           | D2873-045         | NUT PLATE                         |
| 4    | 1           | D2894-1           | SUPPORT                           |
| 5    | 2           | D3190-1           | CHAFING SHIELD                    |
| 6    | 2           | D3595-063-430     | RUBBER CUSHION                    |
| 7    | 14          | MS20601AD4W8      | RIVET (OR NAS9302B-4-8)           |
| 8    | 4           | MS21920-22        | CLAMP                             |
| 9    | 2           | MS21920-25        | CLAMP (OR MS21920-24)             |
| 10   | AR          | SCOTCH-WELD DP460 | EPOXY ADHESIVE, 3M SCOTCH-WELD    |
| 11   | AR          | PROSEAL 890       | SEALANT                           |

#### GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6011-115  
FINISHED LENGTH = 112.91±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT CROSSTUBE PER DART QSI 005 4.2  
FOR HATCHED AREAS (ZN A6-2), MASK AS REQUIRED  
TO APPLY PRIME AND APPLY CLEAR COAT ONLY
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-245" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 27.7 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN-OFF PART: BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2894-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015. LET CURE FOR 24 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-25 CLAMPS WITH D3595-063-430 RUBBER CUSHIONS TO SECURE D2894-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.  
**NOTE: MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.**
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3190-1 CHAFING SHIELDS AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL PROSEAL 890 ON D3190-1 CHAFING SHIELDS ONTO CROSSTUBE BY APPLYING A THIN COAT OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.
- INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS 50 TO 70 DEGREES FROM BOTTOM OF CROSSTUBE OPPOSITE D2894-1 SUPPORT.
- TORQUE CLAMPS 80 TO 100 IN-LB. TORQUE CLAMPS ON D3190-1 CHAFING SHIELD 40 TO 50 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURED FOR 24 HOURS.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 179372 M15  
180618

RELEASED

2015 APR 09

9<sup>th</sup> ECN 15-557

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| G                                                                                                                                                                                                                                                                        | INCORP. DEO's D407-667-245-F1/F2 (ZN D8-1, A8-1, D5-2, B6-2, C6-2); 8.90 WAS 8.53 (ZN D5-2); TORQUE REDUCED FOR CHAFING SHIELD (ZN A8-1); FINISH REVISED TO ALLOW MANUFAC. FLEXIBILITY (ZN C8-1)                                   | RF | 15.03.20 |
| F                                                                                                                                                                                                                                                                        | REFORMAT NOTES TO NEW STANDARDS (ZN B8-1); RELOCATED FLAG # 6 (ZN A8-3) PER NCR 210; REMOVED REF. & ADD TOLERANCES (ZN C6-3, C4-3 & D2-3)                                                                                          | RF | 08.11.06 |
| E                                                                                                                                                                                                                                                                        | 8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: PAR#08-21 AND ECN#1225 | MB | 08.07.24 |
| D                                                                                                                                                                                                                                                                        | ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F, REMOVE -851 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION                                                                                                 | PH | 07.02.07 |
| C                                                                                                                                                                                                                                                                        | ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES                                                                                                                                                                   | PH | 05.07.26 |
| B                                                                                                                                                                                                                                                                        | ADD CHAFING SHIELD                                                                                                                                                                                                                 | CP | 03.05.21 |
| A                                                                                                                                                                                                                                                                        | NEW ISSUE                                                                                                                                                                                                                          | CP | 02.05.13 |
| REV.                                                                                                                                                                                                                                                                     | DESCRIPTION                                                                                                                                                                                                                        | BY | DATE     |
| DESIGN                                                                                                                                                                                                                                                                   | 9 <sup>th</sup>                                                                                                                                                                                                                    |    |          |
| DRAWN                                                                                                                                                                                                                                                                    | RF                                                                                                                                                                                                                                 |    |          |
| CHECKED                                                                                                                                                                                                                                                                  | 9 <sup>th</sup>                                                                                                                                                                                                                    |    |          |
| MFG. APPR.                                                                                                                                                                                                                                                               | 9 <sup>th</sup>                                                                                                                                                                                                                    |    |          |
| APPROVED                                                                                                                                                                                                                                                                 | 9 <sup>th</sup>                                                                                                                                                                                                                    |    |          |
| DE APPR.                                                                                                                                                                                                                                                                 | 9 <sup>th</sup>                                                                                                                                                                                                                    |    |          |
| DATE                                                                                                                                                                                                                                                                     | 15.03.20                                                                                                                                                                                                                           |    |          |
| DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                        |                                                                                                                                                                                                                                    |    |          |
| DRAWING NO. D407-667-245                                                                                                                                                                                                                                                 |                                                                                                                                                                                                                                    |    |          |
| TITLE CROSSTUBE ASS'Y (407 HIGH AFT)                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                    |    |          |
| COPYRIGHT © 2002 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |                                                                                                                                                                                                                                    |    |          |



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



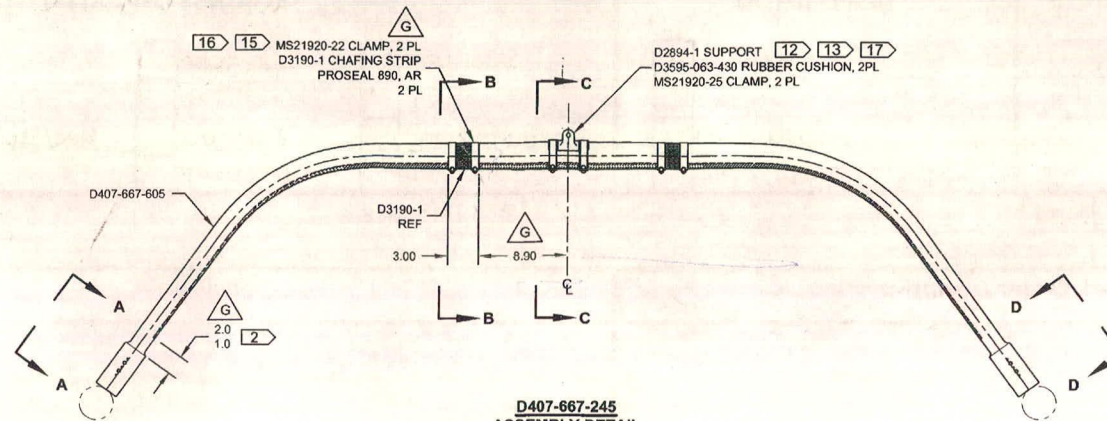
## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

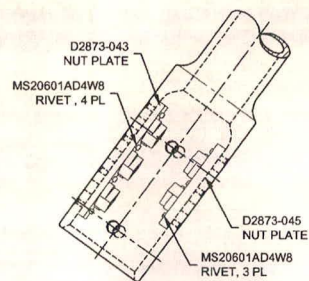
Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube <input type="checkbox"/></td> <td style="border: none;">Cross tube <input type="checkbox"/></td> <td style="border: none;">Water Jet <input type="checkbox"/></td> <td style="border: none;">Engineering <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Machining <input type="checkbox"/></td> <td style="border: none;">Small Fab <input type="checkbox"/></td> <td style="border: none;">Prod. Eng. Coord. <input type="checkbox"/></td> <td style="border: none;">Quality <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Thermoforming <input type="checkbox"/></td> <td style="border: none;">Finishing <input type="checkbox"/></td> <td style="border: none;">Rec/Store/Packaging <input type="checkbox"/></td> <td style="border: none;">Other <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Large Fab <input type="checkbox"/></td> <td style="border: none;">Composite <input type="checkbox"/></td> <td style="border: none;">Supplier <input type="checkbox"/></td> <td></td> </tr> </table> |                                               |                                                 |                                   | Skid-tube <input type="checkbox"/> | Cross tube <input type="checkbox"/>   | Water Jet <input type="checkbox"/>     | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/>    | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/>         | Thermoforming <input type="checkbox"/>      | Finishing <input type="checkbox"/>        | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>   | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/>           | Supplier <input type="checkbox"/>   |                                              |                                           |                                                |                                        |                                   |                                                                                                                                                                                                                                                                                                                                                                                                                              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| Thermoforming <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| <b>Root Cause</b><br><table style="width: 100%; border: none;"> <tr> <td style="border: none;">Environment <input type="checkbox"/></td> <td style="border: none;">No Re-verification <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Design <input type="checkbox"/></td> <td style="border: none;">Operator <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Doc/Data <input type="checkbox"/></td> <td style="border: none;">Offset/Setup <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Equip/Tooling <input type="checkbox"/></td> <td style="border: none;">Supplier <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Handling/Pre <input type="checkbox"/></td> <td style="border: none;">Training <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Material <input type="checkbox"/></td> <td style="border: none;">Use for Testing <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Internal Transport <input type="checkbox"/></td> <td style="border: none;">Poor Information <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Tribal Knowledge <input type="checkbox"/></td> <td style="border: none;">Rushing <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">LOA <input type="checkbox"/></td> <td style="border: none;">Product Improvement <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Substation <input type="checkbox"/></td> <td style="border: none;">Process Improvement <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Past Expiry Date <input type="checkbox"/></td> <td style="border: none;">Manufacturing Process <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Misidentified <input type="checkbox"/></td> <td style="border: none;">Past Due <input type="checkbox"/></td> </tr> </table> |                                                                                                                                                                                    | Environment <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | No Re-verification <input type="checkbox"/>   | Design <input type="checkbox"/>                 | Operator <input type="checkbox"/> | Doc/Data <input type="checkbox"/>  | Offset/Setup <input type="checkbox"/> | Equip/Tooling <input type="checkbox"/> | Supplier <input type="checkbox"/>    | Handling/Pre <input type="checkbox"/> | Training <input type="checkbox"/>  | Material <input type="checkbox"/>          | Use for Testing <input type="checkbox"/> | Internal Transport <input type="checkbox"/> | Poor Information <input type="checkbox"/> | Tribal Knowledge <input type="checkbox"/>    | Rushing <input type="checkbox"/> | LOA <input type="checkbox"/>       | Product Improvement <input type="checkbox"/> | Substation <input type="checkbox"/> | Process Improvement <input type="checkbox"/> | Past Expiry Date <input type="checkbox"/> | Manufacturing Process <input type="checkbox"/> | Misidentified <input type="checkbox"/> | Past Due <input type="checkbox"/> | <b>FAULT CATEGORY</b><br><table style="width: 100%; border: none;"> <tr> <td style="border: none;">Pressure/Forced <input type="checkbox"/></td> <td style="border: none;">Temperature/Cure <input type="checkbox"/></td> <td style="border: none;">Power Loss/Surge <input type="checkbox"/></td> <td style="border: none;">Positioned Wrong <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Bending <input type="checkbox"/></td> <td style="border: none;">Set-up <input type="checkbox"/></td> <td style="border: none;">Folio/Program <input type="checkbox"/></td> <td style="border: none;">Outside Dimensions <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Centre Not Concentric <input type="checkbox"/></td> <td style="border: none;">BOM/Route <input type="checkbox"/></td> <td style="border: none;">Grain <input type="checkbox"/></td> <td style="border: none;">Over/Under tolerance <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Cracks <input type="checkbox"/></td> <td style="border: none;">Broken/Damage/Defect <input type="checkbox"/></td> <td style="border: none;">Weld <input type="checkbox"/></td> <td style="border: none;">Part Incorrect <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Crimp/Kink/Ripple/Wave <input type="checkbox"/></td> <td style="border: none;">Inspection Incomplete/Unqualified <input type="checkbox"/></td> <td style="border: none;">Wrong Stock Pulled <input type="checkbox"/></td> <td style="border: none;">Part Lost/Missing <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Cuffs <input type="checkbox"/></td> <td style="border: none;">Contamination <input type="checkbox"/></td> <td style="border: none;">Out of Sequence <input type="checkbox"/></td> <td style="border: none;">Part Moved <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Crushing <input type="checkbox"/></td> <td style="border: none;">Countersink <input type="checkbox"/></td> <td style="border: none;">Off-set <input type="checkbox"/></td> <td style="border: none;">Drawing <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Heat Treat <input type="checkbox"/></td> <td style="border: none;">Cut Too Short <input type="checkbox"/></td> <td style="border: none;">Mislabeled <input type="checkbox"/></td> <td style="border: none;">Finish <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Wave/Twist in Tube <input type="checkbox"/></td> <td style="border: none;">Instructions Incomplete/Unclear <input type="checkbox"/></td> <td style="border: none;">Fit/Function <input type="checkbox"/></td> <td style="border: none;">Misread <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Marks/Chatter <input type="checkbox"/></td> <td style="border: none;">Drill Holes <input type="checkbox"/></td> <td style="border: none;">Misaligned/off center <input type="checkbox"/></td> <td style="border: none;">Turning Sequence <input type="checkbox"/></td> </tr> </table> |  |  | Pressure/Forced <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/> | Bending <input type="checkbox"/> | Set-up <input type="checkbox"/> | Folio/Program <input type="checkbox"/> | Outside Dimensions <input type="checkbox"/> | Centre Not Concentric <input type="checkbox"/> | BOM/Route <input type="checkbox"/> | Grain <input type="checkbox"/> | Over/Under tolerance <input type="checkbox"/> | Cracks <input type="checkbox"/> | Broken/Damage/Defect <input type="checkbox"/> | Weld <input type="checkbox"/> | Part Incorrect <input type="checkbox"/> | Crimp/Kink/Ripple/Wave <input type="checkbox"/> | Inspection Incomplete/Unqualified <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/> | Cuffs <input type="checkbox"/> | Contamination <input type="checkbox"/> | Out of Sequence <input type="checkbox"/> | Part Moved <input type="checkbox"/> | Crushing <input type="checkbox"/> | Countersink <input type="checkbox"/> | Off-set <input type="checkbox"/> | Drawing <input type="checkbox"/> | Heat Treat <input type="checkbox"/> | Cut Too Short <input type="checkbox"/> | Mislabeled <input type="checkbox"/> | Finish <input type="checkbox"/> | Wave/Twist in Tube <input type="checkbox"/> | Instructions Incomplete/Unclear <input type="checkbox"/> | Fit/Function <input type="checkbox"/> | Misread <input type="checkbox"/> | Marks/Chatter <input type="checkbox"/> | Drill Holes <input type="checkbox"/> | Misaligned/off center <input type="checkbox"/> | Turning Sequence <input type="checkbox"/> |
| Environment <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   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| Internal Transport <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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| Tribal Knowledge <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| Pressure/Forced <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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                                               | Power Loss/Surge <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Positioned Wrong <input type="checkbox"/>     |                                                 |                                   |                                    |                                       |                                        |                                      |                                       |                                    |                                            |                                          |                                             |                                           |                                              |                                  |                                    |                                              |                                     |                                              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| Bending <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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                                               | Folio/Program <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Outside Dimensions <input type="checkbox"/>   |                                                 |                                   |                                    |                                       |                                        |                                      |                                       |                                    |                                            |                                          |                                             |                                           |                                              |                                  |                                    |                                              |                                     |                                              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| Centre Not Concentric <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         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                                               | Grain <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | Over/Under tolerance <input type="checkbox"/> |                                                 |                                   |                                    |                                       |                                        |                                      |                                       |                                    |                                            |                                          |                                             |                                           |                                              |                                  |                                    |                                              |                                     |                                              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| Cracks <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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                                               | Weld <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           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| Crimp/Kink/Ripple/Wave <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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                                               | Wrong Stock Pulled <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             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| Cuffs <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         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                                               | Out of Sequence <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                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| Crushing <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      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                                               | Off-set <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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| Heat Treat <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    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                                               | Mislabeled <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Finish <input type="checkbox"/>               |                                                 |                                   |                                    |                                       |                                        |                                      |                                       |                                    |                                            |                                          |                                             |                                           |                                              |                                  |                                    |                                              |                                     |                                              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| Wave/Twist in Tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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                                               | Fit/Function <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Misread <input type="checkbox"/>              |                                                 |                                   |                                    |                                       |                                        |                                      |                                       |                                    |                                            |                                          |                                             |                                           |                                              |                                  |                                    |                                              |                                     |                                              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| Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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                                               | Misaligned/off center <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | Turning Sequence <input type="checkbox"/>     |                                                 |                                   |                                    |                                       |                                        |                                      |                                       |                                    |                                            |                                          |                                             |                                           |                                              |                                  |                                    |                                              |                                     |                                              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| OTHER : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          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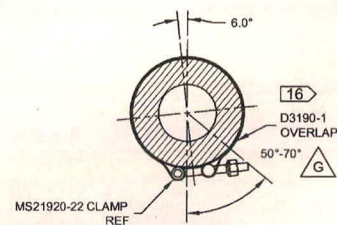




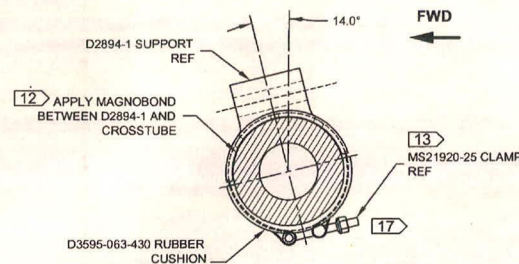
**D407-667-245  
ASSEMBLY DETAIL  
(VIEW LOOKING FWD)**



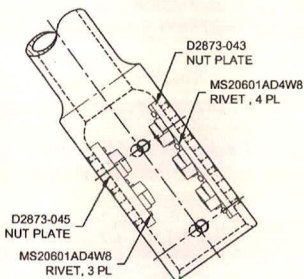
**VIEW A-A CUFF DETAIL  
SCALE 4X**



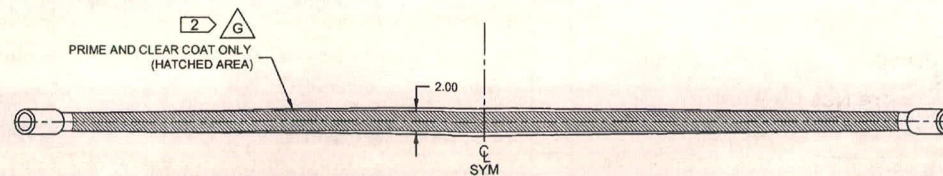
**SECTION B-B  
SCALE 4X, 2PL**



**SECTION C-C  
SCALE 4X**



**VIEW D-D CUFF DETAIL  
SCALE 4X**



**RELEASED**  
2015 APR 09

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|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|----------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                         | 47       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                          | RF       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                        | 47       | DRAWING NO.                            | REV. G       |
| MFG. APPR.                                                                                                                                                                                                                     | 47       | D407-667-245                           | SHEET 2 OF 4 |
| APPROVED                                                                                                                                                                                                                       | 47       | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                       | 47       | CROSSTUBE ASS'Y (407 HIGH AFT)         | NTS          |
| DATE                                                                                                                                                                                                                           | 15.03.20 | COPYRIGHT © 2002 BY DART AEROSPACE LTD |              |
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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



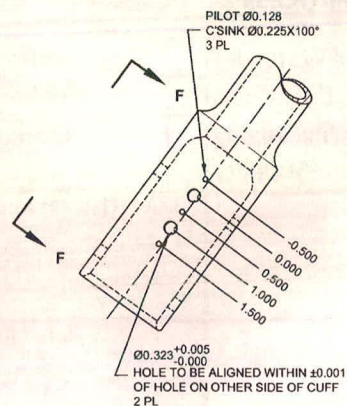
## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

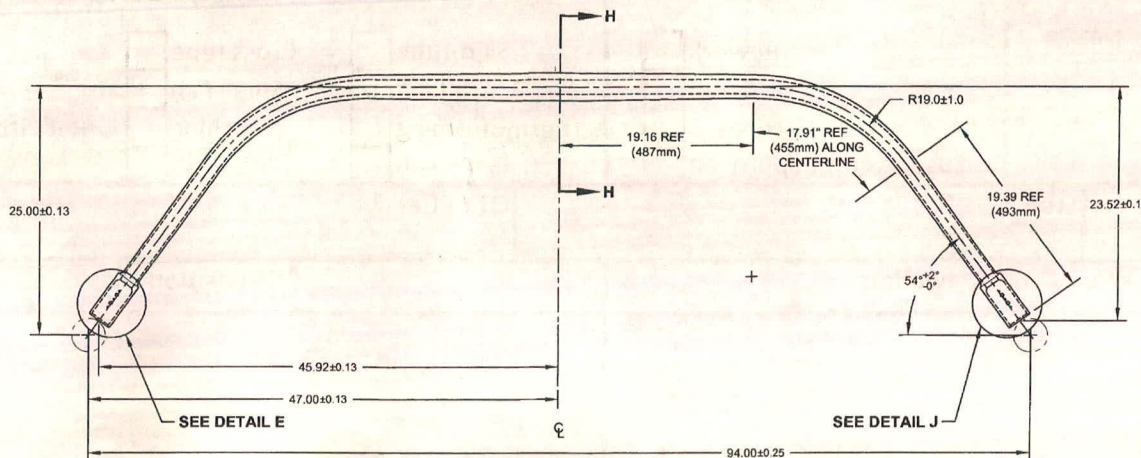
Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                     | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                      |                                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube <input type="checkbox"/></td> <td style="width: 15%;">Cross tube <input type="checkbox"/></td> <td style="width: 15%;">Water Jet <input type="checkbox"/></td> <td style="width: 15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                       |                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Skid-tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Engineering <input type="checkbox"/> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                       |                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Small Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | Quality <input type="checkbox"/>     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                       |                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Finishing <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Other <input type="checkbox"/>       |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                       |                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Composite <input type="checkbox"/>  | Supplier <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                       |                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                     | Step #:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                      | QTY Effective :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | MRB (QS1042) Approval |                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                      | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                       | Completed By                                                                                                                                                                                                                                                                                                                                                                                                            |  |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
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| Root Cause                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                      | FAULT CATEGORY                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                       |                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Environment <input type="checkbox"/><br>Design <input type="checkbox"/><br>Doc/Data <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Pre <input type="checkbox"/><br>Material <input type="checkbox"/><br>Internal Transport <input type="checkbox"/><br>Tribal Knowledge <input type="checkbox"/><br>LOA <input type="checkbox"/><br>Substation <input type="checkbox"/><br>Past Expiry Date <input type="checkbox"/><br>Misidentified <input type="checkbox"/> |                                     | No Re-verification <input type="checkbox"/><br>Operator <input type="checkbox"/><br>Offset/Setup <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Training <input type="checkbox"/><br>Use for Testing <input type="checkbox"/><br>Poor Information <input type="checkbox"/><br>Rushing <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Past Due <input type="checkbox"/> |                                      | Pressure/Forced <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Centre Not Concentric <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  | Temperature/Cure <input type="checkbox"/><br>Set-up <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Inspection Incomplete/Unqualified <input type="checkbox"/><br>Contamination <input type="checkbox"/><br>Countersink <input type="checkbox"/><br>Cut Too Short <input type="checkbox"/><br>Instructions Incomplete/Unclear <input type="checkbox"/><br>Drill Holes <input type="checkbox"/> |                       | Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set <input type="checkbox"/><br>Mislabeled <input type="checkbox"/><br>Fit/Function <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/> |  | Positioned Wrong <input type="checkbox"/><br>Outside Dimensions <input type="checkbox"/><br>Over/Under tolerance <input type="checkbox"/><br>Part Incorrect <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Part Moved <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Misread <input type="checkbox"/><br>Turning Sequence <input type="checkbox"/> |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| OTHER : <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                       |                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |

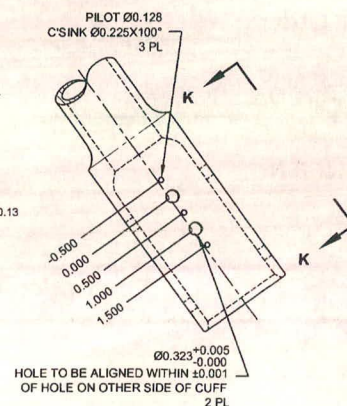




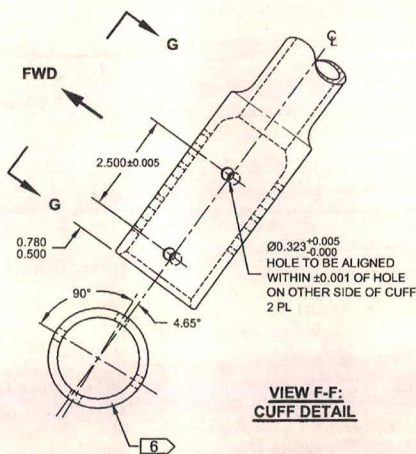
**DETAIL E**  
SCALE 4X  
(VIEW LOOKING FWD)



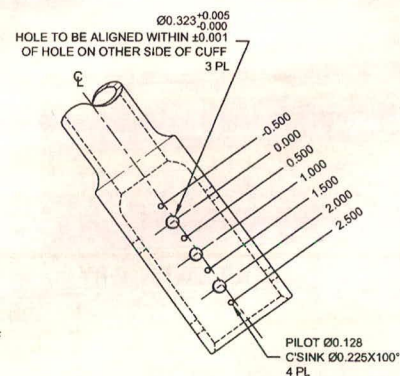
**D407-667-605**  
**BENDING AND DRILLING DETAIL**  
(VIEW LOOKING FWD)



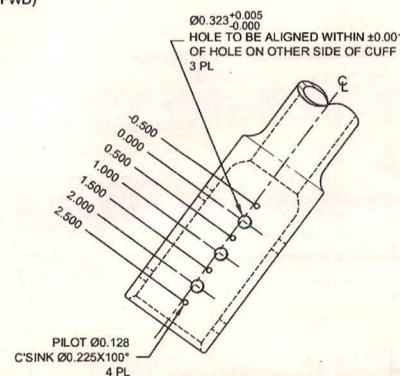
**DETAIL J**  
SCALE 4X  
(VIEW LOOKING FWD)



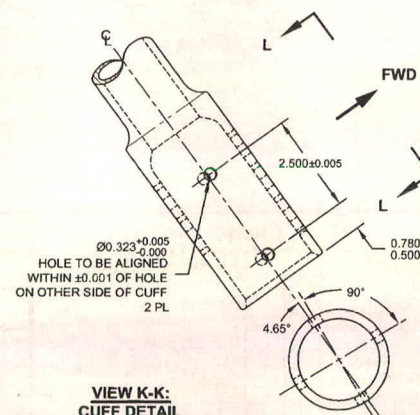
**VIEW F-F:**  
**CUFF DETAIL**



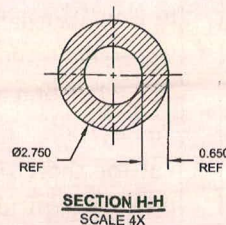
**VIEW G-G**  
(VIEW LOOKING AFT, ROTATED)



**VIEW L-L**  
(VIEW LOOKING AFT, ROTATED)



**VIEW K-K:**  
**CUFF DETAIL**



**SECTION H-H**  
SCALE 4X

**RELEASED**

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| DESIGN                                                                                                                                                                                                                         | q        | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                          | RF       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                        | q        | DRAWING NO.                            | REV. G       |
| MFG. APPR.                                                                                                                                                                                                                     | q        | D407-667-245                           | SHEET 3 OF 4 |
| APPROVED                                                                                                                                                                                                                       | q        | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                       | q        | CROSSTUBE ASS'Y (407 HIGH AFT)         | NTS          |
| DATE                                                                                                                                                                                                                           | 15.03.20 | COPYRIGHT © 2002 BY DART AEROSPACE LTD |              |
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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



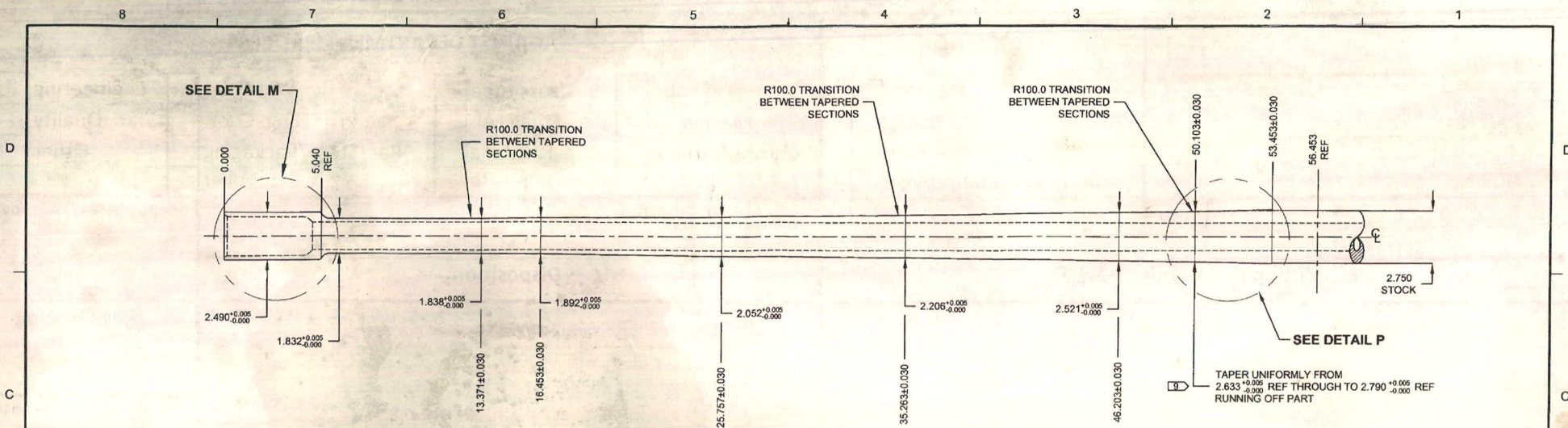
## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

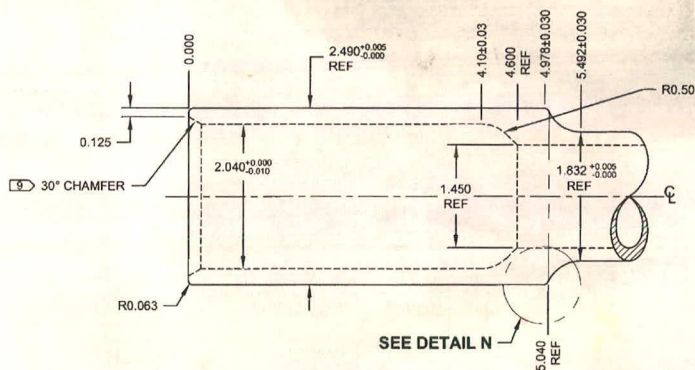
Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                            | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> |                                             | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube <input type="checkbox"/></td> <td style="width: 15%;">Cross tube <input type="checkbox"/></td> <td style="width: 15%;">Water Jet <input type="checkbox"/></td> <td style="width: 15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> |                                   |                                   |                                       |                                              |                                   | Skid-tube <input type="checkbox"/>    | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/>     | Machining <input type="checkbox"/>          | Small Fab <input type="checkbox"/>        | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/>           | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>               | Large Fab <input type="checkbox"/>        | Composite <input type="checkbox"/>             | Supplier <input type="checkbox"/>      |                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  |  |  |  |  |                                          |                                           |                                           |                                  |                                 |                                        |                                                |                                    |                                |                                 |                                               |                               |                                                 |                                                            |                                             |                                |                                        |                                          |                                   |                                      |                                  |                                     |                                        |                                     |                                             |                                                          |                                       |                                        |                                      |                                                |
| Skid-tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     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| Machining <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Small Fab <input type="checkbox"/>                         | Prod. 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| Thermoforming <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Large Fab <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     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| <b>Root Cause</b><br><table style="width: 100%; border: none;"> <tr> <td style="width: 50%;">Environment <input type="checkbox"/></td> <td style="width: 50%;">No Re-verification <input type="checkbox"/></td> </tr> <tr> <td>Design <input type="checkbox"/></td> <td>Operator <input type="checkbox"/></td> </tr> <tr> <td>Doc/Data <input type="checkbox"/></td> <td>Offset/Setup <input type="checkbox"/></td> </tr> <tr> <td>Equip/Tooling <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> </tr> <tr> <td>Handling/Pre <input type="checkbox"/></td> <td>Training <input type="checkbox"/></td> </tr> <tr> <td>Material <input type="checkbox"/></td> <td>Use for Testing <input type="checkbox"/></td> </tr> <tr> <td>Internal Transport <input type="checkbox"/></td> <td>Poor Information <input type="checkbox"/></td> </tr> <tr> <td>Tribal Knowledge <input type="checkbox"/></td> <td>Rushing <input type="checkbox"/></td> </tr> <tr> <td>LOA <input type="checkbox"/></td> <td>Product Improvement <input type="checkbox"/></td> </tr> <tr> <td>Substation <input type="checkbox"/></td> <td>Process Improvement <input type="checkbox"/></td> </tr> <tr> <td>Past Expiry Date <input type="checkbox"/></td> <td>Manufacturing Process <input type="checkbox"/></td> </tr> <tr> <td>Misidentified <input type="checkbox"/></td> <td>Past Due <input type="checkbox"/></td> </tr> </table> |                                                            | Environment <input type="checkbox"/>                                                                                                                                               | No Re-verification <input type="checkbox"/> | Design <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Operator <input type="checkbox"/> | Doc/Data <input type="checkbox"/> | Offset/Setup <input type="checkbox"/> | Equip/Tooling <input type="checkbox"/>       | Supplier <input type="checkbox"/> | Handling/Pre <input type="checkbox"/> | Training <input type="checkbox"/>   | Material <input type="checkbox"/>  | Use for Testing <input type="checkbox"/> | Internal Transport <input type="checkbox"/> | Poor Information <input type="checkbox"/> | Tribal Knowledge <input type="checkbox"/>  | Rushing <input type="checkbox"/> | LOA <input type="checkbox"/>           | Product Improvement <input type="checkbox"/> | Substation <input type="checkbox"/>          | Process Improvement <input type="checkbox"/> | Past Expiry Date <input type="checkbox"/> | Manufacturing Process <input type="checkbox"/> | Misidentified <input type="checkbox"/> | Past Due <input type="checkbox"/> | <b>FAULT CATEGORY</b><br><table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Pressure/Forced <input type="checkbox"/></td> <td style="width: 33%;">Temperature/Cure <input type="checkbox"/></td> <td style="width: 33%;">Power Loss/Surge <input type="checkbox"/></td> </tr> <tr> <td>Bending <input type="checkbox"/></td> <td>Set-up <input type="checkbox"/></td> <td>Folio/Program <input type="checkbox"/></td> </tr> <tr> <td>Centre Not Concentric <input type="checkbox"/></td> <td>BOM/Route <input type="checkbox"/></td> <td>Grain <input type="checkbox"/></td> </tr> <tr> <td>Cracks <input type="checkbox"/></td> <td>Broken/Damage/Defect <input type="checkbox"/></td> <td>Weld <input type="checkbox"/></td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave <input type="checkbox"/></td> <td>Inspection Incomplete/Unqualified <input type="checkbox"/></td> <td>Wrong Stock Pulled <input type="checkbox"/></td> </tr> <tr> <td>Cuffs <input type="checkbox"/></td> <td>Contamination <input type="checkbox"/></td> <td>Out of Sequence <input type="checkbox"/></td> </tr> <tr> <td>Crushing <input type="checkbox"/></td> <td>Countersink <input type="checkbox"/></td> <td>Off-set <input type="checkbox"/></td> </tr> <tr> <td>Heat Treat <input type="checkbox"/></td> <td>Cut Too Short <input type="checkbox"/></td> <td>Mislabeled <input type="checkbox"/></td> </tr> <tr> <td>Wave/Twist in Tube <input type="checkbox"/></td> <td>Instructions Incomplete/Unclear <input type="checkbox"/></td> <td>Fit/Function <input type="checkbox"/></td> </tr> <tr> <td>Marks/Chatter <input type="checkbox"/></td> <td>Drill Holes <input type="checkbox"/></td> <td>Misaligned/off center <input type="checkbox"/></td> </tr> </table> |  |  |  |  |  | Pressure/Forced <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/> | Bending <input type="checkbox"/> | Set-up <input type="checkbox"/> | Folio/Program <input type="checkbox"/> | Centre Not Concentric <input type="checkbox"/> | BOM/Route <input type="checkbox"/> | Grain <input type="checkbox"/> | Cracks <input type="checkbox"/> | Broken/Damage/Defect <input type="checkbox"/> | Weld <input type="checkbox"/> | Crimp/Kink/Ripple/Wave <input type="checkbox"/> | Inspection Incomplete/Unqualified <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/> | Cuffs <input type="checkbox"/> | Contamination <input type="checkbox"/> | Out of Sequence <input type="checkbox"/> | Crushing <input type="checkbox"/> | Countersink <input type="checkbox"/> | Off-set <input type="checkbox"/> | Heat Treat <input type="checkbox"/> | Cut Too Short <input type="checkbox"/> | Mislabeled <input type="checkbox"/> | Wave/Twist in Tube <input type="checkbox"/> | Instructions Incomplete/Unclear <input type="checkbox"/> | Fit/Function <input type="checkbox"/> | Marks/Chatter <input type="checkbox"/> | Drill Holes <input type="checkbox"/> | Misaligned/off center <input type="checkbox"/> |
| Environment <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   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| Equip/Tooling <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Handling/Pre <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  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| Material <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      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| Internal Transport <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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| Tribal Knowledge <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| LOA <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           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| Substation <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    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| Past Expiry Date <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              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| Misidentified <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Pressure/Forced <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| Bending <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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| Centre Not Concentric <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         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| Cracks <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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| Crimp/Kink/Ripple/Wave <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        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| Cuffs <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         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| Crushing <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      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| Heat Treat <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    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| Wave/Twist in Tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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| Marks/Chatter <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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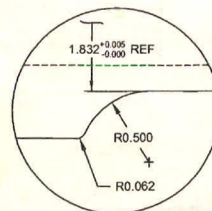




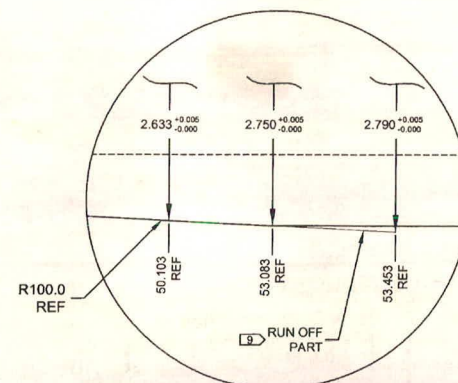
**D407-667-245 MACHINING DETAIL**



**DETAIL M: CROSSTUBE CUFF**  
SCALE 3X



**DETAIL N: CUFF TRANSITION**  
SCALE 2X



**DETAIL P: TAPER RUN-OFF**  
NOT TO SCALE

**RELEASED**

2015 APR 09

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| DESIGN                                                                                                                                                                                                                         | qf       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                          | RF       | <b>HAWKESBURY, ONTARIO, CANADA</b>     |              |
| CHECKED                                                                                                                                                                                                                        | qf       | DRAWING NO.                            | REV. G       |
| MFG. APPR.                                                                                                                                                                                                                     | qf       | D407-667-245                           | SHEET 4 OF 4 |
| APPROVED                                                                                                                                                                                                                       | qf       | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                       | qf       | CROSSTUBE ASS'Y (407 HIGH AFT)         | NTS          |
| DATE                                                                                                                                                                                                                           | 15.03.20 | COPYRIGHT © 2002 BY DART AEROSPACE LTD |              |
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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/>                                                                                                                                                                                                                                          |                                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube <input type="checkbox"/></td> <td style="border: none;">Cross tube <input type="checkbox"/></td> <td style="border: none;">Water Jet <input type="checkbox"/></td> <td style="border: none;">Engineering <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Machining <input type="checkbox"/></td> <td style="border: none;">Small Fab <input type="checkbox"/></td> <td style="border: none;">Prod. Eng. Coord. <input type="checkbox"/></td> <td style="border: none;">Quality <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Thermoforming <input type="checkbox"/></td> <td style="border: none;">Finishing <input type="checkbox"/></td> <td style="border: none;">Rec/Store/Packaging <input type="checkbox"/></td> <td style="border: none;">Other <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Large Fab <input type="checkbox"/></td> <td style="border: none;">Composite <input type="checkbox"/></td> <td style="border: none;">Supplier <input type="checkbox"/></td> <td style="border: none;"></td> </tr> </table> |  |                                                                                                                                                                                                                                                                                                                                                                                                                        |                       |                                                                                                                                                                                                                                                                                                                                                                                                                                   |  | Skid-tube <input type="checkbox"/> | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Cross tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | Water Jet <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                          | Engineering <input type="checkbox"/> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                        |                       |                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Small Fab <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Prod. Eng. Coord. <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                  | Quality <input type="checkbox"/>     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                        |                       |                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
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| Large Fab <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Composite <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Supplier <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                           |                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                        |                       |                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
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| Root Cause                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | FAULT CATEGORY                                                                                                                                                                                                                                                                                                                                                                                                              |                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                        |                       |                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Environment <input type="checkbox"/><br>Design <input type="checkbox"/><br>Doc/Data <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Pre <input type="checkbox"/><br>Material <input type="checkbox"/><br>Internal Transport <input type="checkbox"/><br>Tribal Knowledge <input type="checkbox"/><br>LOA <input type="checkbox"/><br>Substation <input type="checkbox"/><br>Past Expiry Date <input type="checkbox"/><br>Misidentified <input type="checkbox"/> | No Re-verification <input type="checkbox"/><br>Operator <input type="checkbox"/><br>Offset/Setup <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Training <input type="checkbox"/><br>Use for Testing <input type="checkbox"/><br>Poor Information <input type="checkbox"/><br>Rushing <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Past Due <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Centre Not Concentric <input type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/> |                                      | Temperature/Cure <input type="checkbox"/><br>Set-up <input type="checkbox"/><br>BOM/Route <input type="checkbox"/><br>Broken/Damage/Defect <input type="checkbox"/><br>Inspection Incomplete/Unqualified <input type="checkbox"/><br>Contamination <input type="checkbox"/><br>Countersink <input type="checkbox"/><br>Cut Too Short <input type="checkbox"/><br>Instructions Incomplete/Unclear <input type="checkbox"/><br>Drill Holes <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  | Power Loss/Surge <input type="checkbox"/><br>Folio/Program <input type="checkbox"/><br>Grain <input type="checkbox"/><br>Weld <input type="checkbox"/><br>Wrong Stock Pulled <input type="checkbox"/><br>Out of Sequence <input type="checkbox"/><br>Off-set <input type="checkbox"/><br>Misabeled <input type="checkbox"/><br>Fit/Function <input type="checkbox"/><br>Misaligned/off center <input type="checkbox"/> |                       | Positioned Wrong <input type="checkbox"/><br>Outside Dimensions <input type="checkbox"/><br>Over/Under tolerance <input type="checkbox"/><br>Part Incorrect <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Part Moved <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Misread <input type="checkbox"/><br>Turning Sequence <input type="checkbox"/> |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                             |                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                        |                       |                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| OTHER :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                             |                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                                                                                                                                                                                                                                                                                                                        |                       |                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |





Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# **PURCHASE ORDER** **PO040976**

**Supplier:** SKY002-VC  
Skyservice  
6120 Midfield Road  
Mississauga  
ON  
L5P 1B1 Canada  
Phone: 905-678-5636  
Fax: 905-678-5841

**PO No:** PO040976  
**PO Date:** 9/11/18  
**Due Date:** 9/13/18  
**Purchase Order Revision:**  
**Revision Date:**  
**Ship-To Contact:** Lavoie, Chantal  
Phone: clavoie@dartaero.com

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**Via:** Ground  
**Pynt Terms:** Net 30  
**Freight Terms:**  
**Special Comments:**

## Items

| Line Item         | Job    | Part         | Description                                                                                                                                                                                                                                                                                                                                         | Status | Account | Due Date | Order Quantity | Received Quantity | Balance  | Unit Price (CAD) | Extended Price  |
|-------------------|--------|--------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---------|----------|----------------|-------------------|----------|------------------|-----------------|
| 1                 | 180615 | D4464-041    | Fuel Tank Assembly<br>: Various STC's<br>ISSUE P/O<br><br>LIQUID PENETRANT<br>INSPECTION AS PER QSI<br>038 OR<br>LPI AS PER ASTM 1417<br>LEVEL 2                                                                                                                                                                                                    | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$116.17647/pcs  | \$116.18        |
| 2                 | 178952 | D407-667-205 | Aft Crosstube - High 407<br>: TC STC SH01-5 Issue 3,<br>FAA STC SR01304NY<br>05/12/15, JCAB JAPAN<br>STC-32-OSA 02/02/28,<br>EASA STC<br>EASA.IM.R.S.01179<br>06/07/03, BRAZIL<br>2009S08-16 09/08/25,<br>BRAZIL 2009S08-17<br>09/08/25<br>*** WEAR LATEX GLOVES<br>WHEN HANDLING<br>CROSSTUBE*** Liquid<br>Penetrant Inspection as per<br>QSI 0380 | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$116.17647/pcs  | \$116.18        |
| 179372            |        |              | SEP 13 2018                                                                                                                                                                                                                                                                                                                                         | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$116.17647/pcs  | \$116.18        |
| 179373            |        |              | SEP 13 2018                                                                                                                                                                                                                                                                                                                                         | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$116.17647/pcs  | \$116.18        |
| 179374            |        |              | SEP 13 2018                                                                                                                                                                                                                                                                                                                                         | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$116.17647/pcs  | \$116.18        |
| 181961            |        |              | SEP 13 2018                                                                                                                                                                                                                                                                                                                                         | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$116.17647/pcs  | \$116.18        |
| 181962            |        |              | SEP 13 2018                                                                                                                                                                                                                                                                                                                                         | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs    | \$116.17647/pcs  | \$116.18        |
| <b>Sub Total:</b> |        |              |                                                                                                                                                                                                                                                                                                                                                     |        |         |          | <b>6</b>       | <b>0</b>          | <b>6</b> |                  | <b>\$697.06</b> |









Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# **PURCHASE ORDER** **PO040976**

| Items      |        |              |                                                                                                                                                                                                                                                                                                                                                                                                                             |        |         |          |                |                   |         |                  |                |
|------------|--------|--------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|---------|----------|----------------|-------------------|---------|------------------|----------------|
| Line Item  | Job    | Part         | Description                                                                                                                                                                                                                                                                                                                                                                                                                 | Status | Account | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD) | Extended Price |
| 3          | 174618 | D350-748-101 | FWD Crosstube AS350 / AS355<br>: TC STC SH06-27 Issue 2,<br>FAA STC SR02359NY<br>11/03/04, EASA STC<br>EASA.10016903 Revision 2<br>10/09/03, BRAZIL<br>2009S04-04 09/04/06<br>Issue P/O:<br><br>Stress relief at 375degree<br>for 5hrs<br>Magnetic Particle Inspect<br>per ASTM E1444<br>Cad Plate per AMS-QQ-P-<br>416B, Class 1, Type 2<br>Embrittle relief at 375<br>degree for 8 hrs, Chromate<br>Treat<br>C of C req'd | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$116.17647/pcs  | \$116.18       |
|            |        |              |                                                                                                                                                                                                                                                                                                                                                                                                                             |        |         |          |                |                   |         | SEP 13 2018      |                |
|            | 174634 | 1 X          |                                                                                                                                                                                                                                                                                                                                                                                                                             | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$116.17647/pcs  | \$116.18       |
|            | 174639 | 1 X          |                                                                                                                                                                                                                                                                                                                                                                                                                             | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$116.17647/pcs  | \$116.18       |
|            | 174642 | 1 X          |                                                                                                                                                                                                                                                                                                                                                                                                                             | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$116.17647/pcs  | \$116.18       |
|            | 174643 | 1 X          |                                                                                                                                                                                                                                                                                                                                                                                                                             | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$116.17647/pcs  | \$116.18       |
| Sub Total: |        |              |                                                                                                                                                                                                                                                                                                                                                                                                                             |        |         |          | 5              | 0                 | 5       |                  | \$580.88       |
| 4          | 174673 | D350-748-201 | Aft Crosstube AS350 / AS355<br>: TC STC SH06-27 Issue 2,<br>FAA STC SR02359NY<br>11/03/04, EASA STC<br>EASA.10016903 Revision 2<br>10/09/03, BRAZIL<br>2009S04-04 09/04/06<br>ISSUE P/O TO<br>METCOR:<br>AFTER BENDING:<br>STRESS RELIEF AT 650°<br>F ± 25° F FOR A MINIMUM<br>OF<br>2 HRS AIR COOL TO<br>AMBIENT TEMPERATURE<br>note: crosstube made from<br>4130 seamless steel tube<br><br>DETAIL C OF C<br>REQUIRED     | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$116.17647/pcs  | \$116.18       |
|            |        |              |                                                                                                                                                                                                                                                                                                                                                                                                                             |        |         |          |                |                   |         | SEP 13 2018      |                |
|            | 174674 | 1 X          |                                                                                                                                                                                                                                                                                                                                                                                                                             | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$116.17647/pcs  | \$116.18       |
|            | 174676 | 1 X          |                                                                                                                                                                                                                                                                                                                                                                                                                             | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$116.17647/pcs  | \$116.18       |
|            | 181140 | 1 X          |                                                                                                                                                                                                                                                                                                                                                                                                                             | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$116.17647/pcs  | \$116.18       |
|            | 181141 | 1 X          |                                                                                                                                                                                                                                                                                                                                                                                                                             | Firmed | -       | 9/13/18  | 1 pcs          | 0 pcs             | 1 pcs   | \$116.17647/pcs  | \$116.18       |
| Sub Total: |        |              |                                                                                                                                                                                                                                                                                                                                                                                                                             |        |         |          | 5              | 0                 | 5       |                  | \$580.88       |









Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# **PURCHASE ORDER** **PO040976**

| Items     |     |      |             |        |         |          |                |                   |         |                         |
|-----------|-----|------|-------------|--------|---------|----------|----------------|-------------------|---------|-------------------------|
| Line Item | Job | Part | Description | Status | Account | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (CAD)        |
|           |     |      |             |        |         |          |                |                   |         | Extended Price          |
|           |     |      |             |        |         |          |                |                   |         | Grand Total: \$1,975.00 |

## Order Notes

Procurement Quality Clauses  
A005 right of entry  
A012 chemical and physical test report  
A016 personnel qualification  
A017 raw material identification (as applicable)

A022 Apical Processing  
A024 process certifications  
A026 certification of material conformance

A041 quality management system  
A042 dart notification by supplier  
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

Plex 9/13/18 7:53 AM dart.lavoie.chantal









Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

## SUBCONTRACT SHIPPER

| SUBCONTRACT SHIP TO                                                                                                                       | SHIPPER                                                                                                                                                         |
|-------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Ship To:</b> Skyservice<br>6120 Midfield Road<br>Mississauga, ON L5P 1B1 Canada<br><b>Phone:</b> 905-678-5636 <b>Fax:</b> 905-678-5841 | <b>Shipper No:</b> 614<br><b>Shipper Date:</b> 9/13/18<br><b>Carrier:</b> *<br><b>Ship Via:</b><br><b>Vehicle Reg:</b><br><b>Note:</b><br><b>Freight Terms:</b> |

### Part Information

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                                                                                                                                                                             |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Part No:</b> D350-748-101<br><b>Cust Part No:</b> D350-748-101<br><b>Reference No:</b><br><b>Part Information Note:</b> DWG REV H IPP Rev:A New Issue 06-07-05 JLM<br>IPP Rev:B Update qty of MS21042L5 06-09-12 KJ<br>VERIFY BY:DD IPP Rev:C Rev B 07-11-15 DD IPP<br>Rev D Combined manufacturing 08.04.02 EC verified<br>by: DD IPP Rev:E 08-06-24 revD as per dwg DD<br>verified by:EC IPP Rev:F 10.08.04 added QSI010 4.3<br>DD verf:EC IPP REV:G ADD UNDER BEND<br>COMMENT 12-05-28 JLM IPP REV:H 12.11.05 as<br>per dwg D350-748-141G DD verf:JLM IPP REV:I<br>15.03.19 as per dwg D350-748-141revH dd verf:jlm<br><br><b>Drawing No:</b><br><b>Program:</b><br><b>Program Customer:</b><br><b>Addl Docs:</b><br><b>Commercial:</b> Product Line: Crosstube - High<br>Primary OEM Application: Airbus<br>Manufacturer: DART<br>Advertised on web?: No<br>Shipping Dims & Weights: Metric: L2.29m x W0.86m x<br>H0.18m,Actual Weight of 26.31 kg<br>Shipping Dims & Weights: Imperial: L90" x W34" x<br>H7",Actual Weight of 58 lbs | <b>Name:</b> FWD Crosstube AS350 / AS355<br><b>Product Family:</b> Landing Gear<br><b>Piece Weight:</b> 0 lbs<br><b>Alloy Type:</b><br><b>Alloy - Temper:</b> -<br><b>Description:</b> TC STC SH06-27 Issue 2, FAA STC SR02359NY<br>11/03/04, EASA STC EASA.10016903 Revision 2<br>10/09/03, BRAZIL 2009S04-04 09/04/06<br><b>Quantity:</b> |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

### OPERATION

**Operation:** Outsource - 174  
**Description:** ISSUE P/O TO SKYSERVICE: \_\_\_\_\_  
**Note:**

### DETAIL

| Part                                                                                                                                                              | Operation                                          | PO       | Job    | Container | Heat Code | Net Weight (lbs) | Gross Weight (lbs) | Quantity |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------|----------|--------|-----------|-----------|------------------|--------------------|----------|
| <b>D350-748-101</b><br>09/20/2017 LMC Can Only Be Sold To AVIC. Discontinued And Replaced By D350-748-103. Oversized Item, Please Refer To Shipping Instructions. | <b>Outsource</b><br>ISSUE P/O TO SKYSERVICE: _____ | PO040976 | 174634 | S093239   |           | 0                | 0                  | 1        |
|                                                                                                                                                                   |                                                    |          | 174639 | S093544   |           | 0                | 0                  | 1        |
|                                                                                                                                                                   |                                                    |          | 174642 | S093602   |           | 0                | 0                  | 1        |
|                                                                                                                                                                   |                                                    |          | 174618 | S093751   |           | 0                | 0                  | 1        |
|                                                                                                                                                                   |                                                    |          | 174643 | S093762   |           | 0                | 0                  | 1        |
| <b>D350-748-201</b><br>09/20/2017 LMC Can Only Be Sold To Avic. Discontinued And Replaced By D350-748-203.                                                        | <b>Outsource</b><br>ISSUE P/O TO SKYSERVICE: _____ | PO040976 | 174673 | S094573   |           | 0                | 0                  | 1        |







9/13/2018

[Dart Hawkesbury] Subcontract Shipper - Lavoie, Chantal

Oversized Item, Please Refer  
To Shipping Instructions.

|                                                                                                                                                                                                                                                       |                                                                                                    |                 |              |           |  |          |          |           |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------|-----------------|--------------|-----------|--|----------|----------|-----------|
|                                                                                                                                                                                                                                                       |                                                                                                    |                 | 174674       | S094587   |  | 0        | 0        | 1         |
|                                                                                                                                                                                                                                                       |                                                                                                    |                 | 174676       | S094598   |  | 0        | 0        | 1         |
|                                                                                                                                                                                                                                                       |                                                                                                    |                 | 181140       | S095319   |  | 0        | 0        | 1         |
|                                                                                                                                                                                                                                                       |                                                                                                    |                 | 181141       | S095366   |  | 0        | 0        | 1         |
| <b>D407-667-205</b>                                                                                                                                                                                                                                   | <b>Outsource</b>                                                                                   | <b>PO040976</b> | 181961       | S103098   |  | 0        | 0        | 1         |
| 09/20/2017JR Oversized Item,<br>Please Refer To Shipping<br>Instructions.                                                                                                                                                                             | *** WEAR LATEX GLOVES WHEN HANDLING<br>CROSSTUBE*** Liquid Penetrant Inspection as<br>per QSI 0380 |                 |              |           |  |          |          |           |
|                                                                                                                                                                                                                                                       |                                                                                                    |                 | 178952       | S103104   |  | 0        | 0        | 1         |
|                                                                                                                                                                                                                                                       |                                                                                                    |                 | 179373       | S103183   |  | 0        | 0        | 1         |
|                                                                                                                                                                                                                                                       |                                                                                                    |                 | 179372       | S103185   |  | 0        | 0        | 1         |
|                                                                                                                                                                                                                                                       |                                                                                                    |                 | 181962       | S103187   |  | 0        | 0        | 1         |
|                                                                                                                                                                                                                                                       |                                                                                                    |                 | 179374       | S103902   |  | 0        | 0        | 1         |
| <b>D4464-041</b>                                                                                                                                                                                                                                      | <b>Outsource</b>                                                                                   | <b>PO040976</b> | 180615       | S100152   |  | 0        | 0        | 1         |
| 09/20/2017JR D4464-041 Aux<br>Fuel Tank Reservoir (Ref.<br>D350-794-141) Is About 0.25"<br>Longer Than The D4055-041<br>Aux Fuel Tank Reservoir (Ref.<br>D350-794-041); Please<br>Contact Technical Support For<br>More Details (Ref.: Case<br>9383). | ISSUE P/O : _____ LIQUID<br>PENETRANT INSPECTION AS PER QSI 038<br>OR LPI AS PER ASTM 1417 LEVEL 2 |                 |              |           |  |          |          |           |
|                                                                                                                                                                                                                                                       |                                                                                                    |                 | <b>Total</b> | <b>17</b> |  | <b>0</b> | <b>0</b> | <b>17</b> |

Driver Signature

Customer Copy

Plex 9/13/18 8:03 AM dart.lavoie.chantal







**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

|                |                               |               |                     |
|----------------|-------------------------------|---------------|---------------------|
| WO #: MWO37372 | Customer: Dart Aerospace Ltd. | Dept: NDT YUL | Reference: PO040976 |
| Descr:         | PN:                           | S/N:          | Qty: 1              |
| Make:          | Model:                        | Reg:          | A/C S/N:            |
| TSN:           | CSN:                          | TSO:          |                     |

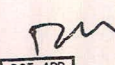
**Task: UNSCHEDULED****Sequence: 1****Work Required:****CARRY OUT NDT ON:**

1 FUEL TANK , P/N# D4464-041 , J/S# 180615 ✓

6 AFT CROSSTUBES , P/N# D407-667-205 , J/S# 181961 , 181962 , 179372 , 179373 , 179374 , 178952 ✓

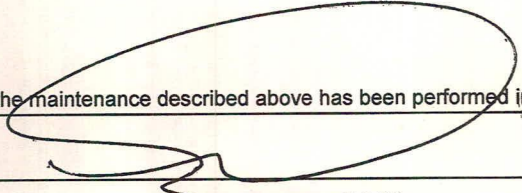
5 FWD CROSSTUBES , P/N# D350-748-101 , J/S# 174618 , 174639 , 174642 , 174643 , 174634 ✓

5 AFT CROSSTUBES , P/N D350-748-201 , J/S# 174673 , 174674 , 174676 , 181140 , 181141 ✓

|                                                                                                                                                                                                 |              |                                                                                                                 |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|-----------------------------------------------------------------------------------------------------------------|
| <b>Action Taken:</b>                                                                                                                                                                            | <b>Date:</b> | <b>Initial/Stamp:</b>                                                                                           |
| LPI C/O IAW ASTM E-1417 REV. 16<br><br>3 LEAKS FOUND IN FUEL TANK<br><br>REMAINING ITEMS: NO CRACK FOUND<br><br>PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142 | SEP 11 2018  | <br>DOT-APP<br>20<br>53-89 |

| Description | Location | P/N | Qty | Batch | S/N Off | S/N On |
|-------------|----------|-----|-----|-------|---------|--------|
|             |          |     |     |       |         |        |
|             |          |     |     |       |         |        |
|             |          |     |     |       |         |        |
|             |          |     |     |       |         |        |
|             |          |     |     |       |         |        |
|             |          |     |     |       |         |        |

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

|                                                                                                |                                                                                                        |                      |
|------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------|----------------------|
| Signature:  | ACA/SCA Stamp<br> | Date:<br>SEP 11 2018 |
| Name: <b>RAEIK MELIKIAN</b>                                                                    |                                                                                                        |                      |



